HEAT LOCK™

Iron-On Veneer Adhesive

RIGID GLUE LINE
ELIMINATES CREEPING,
PREVENTS DE-LAMINATION
AND MAKES EDGES STRONGER!

"The Heat Lock adhesive has opened up countless possibilities by making curved and complex veneer work much easier."
-Raymond C. Cole Jr.
Custom Cabinetry & Fine Furniture LLC

Heat Lock™ Adhesive
Makes Veneering Fast, Easy, and Affordable
For Hobbyist Woodworkers and Professional Craftsmen

Imagine veneering with walnut burl, quilted maple, curly sycamore, or another exotic wood without the expense of a vacuum system. Imagine veneering without the fumes of contact cement. Imagine completing a veneered panel in a matter of minutes.

Heat Lock™ veneering is what you just imagined.

Designed specifically for iron-on veneering, Heat Lock bonds raw and paper-backed veneers to common substrates such as wood, plywood, MDF, and particle board with an ordinary household clothes iron.

Available in pint and gallon sizes.

Fast-bonding Heat Lock allows projects to be stained and finished on the same day. The high solid content in Heat Lock dries to a rigid glue line that eliminates creeping, prevents de-lamination, and makes edges stronger.

Unlike other veneer adhesives, Heat Lock cleans up with water and emits no V.O.C.'s. So it's user friendly and environmentally safe.

Heat Lock is ideal for curved table aprons, DIY stereo speakers, cylinder pedestals, standard flat panels, and any irregular shape too difficult to use in a vacuum press.

Fast, easy, and affordable veneering... Imagine that!

Veneer Supplies.com

Better Bond™ EXTREME PERFORMANCE ADHESIVES

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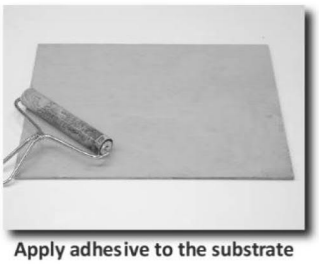
Iron-On Veneering with Better Bond Heat Lock™

Heat Lock is a superb adhesive that takes only a small amount of practice to master, but it is best to create a test panel with veneer scraps before any project work begins. A glue roller, clothes iron, scissors, masking tape, and an unbacked or paper-backed veneer no thicker than 1/30" will be needed.

> QUICK TIP ***The Heat Lock™ product page at VeneerSupplies.com has answers to more than 40 frequently asked questions about this adhesive.***



Apply adhesive to the substrate

Prepare the Substrate

Heat Lock will work with a variety of porous substrate materials such as plywood, MDF, and particle board. Be certain that the substrate surface is free of surface contaminates and is lightly scuffed with 80 grit sandpaper.

Apply adhesive to the veneer

Prepare the Veneer

It may be helpful to cut the veneer one inch larger in width and length than the substrate surface. Before applying the adhesive, it is often best to "dry iron" the veneer to minimize the potential for splitting. Start by placing the veneer on a smooth, firm surface suitable for heat. Then set the iron to the medium level and allow it time to reach operating temperature. Next, move the iron over the entire veneer surface, allowing no more than 5 seconds of heat on any part.

If the veneer has been cut over-sized, tape the edges to a scrap board. This will help control veneer curling and prevent the adhesive from getting on the front of the veneer during application.

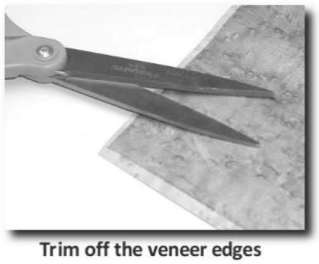
Allow time for adhesive to dry

Apply the Heat Lock Adhesive

A foam paint roller or paint brush can be used to spread the adhesive, but a veneer glue roller is the best application tool because it applies a thick, even, and level coat of adhesive. Glue rollers are available at VeneerSupplies.com. The key is to apply Heat Lock evenly. This can be accomplished by drawing pencil lines on the substrate from edge to edge. If the pencil lines are half-obscured by the layer of wet adhesive, then the right amount has likely been applied.

Apply the adhesive to the project surface in multiple Z-shaped patterns. Use the glue roller to evenly spread the adhesive over the entire project surface. Add more adhesive to the surface if necessary. If the adhesive drips over the edge, it can be cleaned up (while wet) with a damp paper towel. Then apply the adhesive to the veneer in the same manner.

Allow 20 to 45 minutes for both adhesive surfaces to dry. Drying time depends on the ambient humidity and temperature in the work space. A second coat can be applied if the first appears too thin after it dries.



Trim off the veneer edges

Clean the Application Tool

Clean the roller or brush with warm water while the adhesive is still wet.

Bond the Veneer to the Project Surface

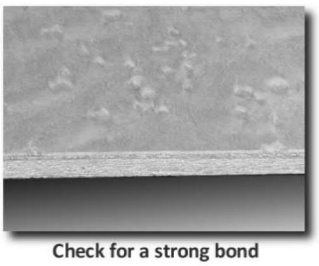
Turn on the clothes iron after the Heat Lock adhesive on the veneer and substrate has fully dried. Set the iron to medium/high and turn off the steam option. Do not delay the ironing process once the adhesive has dried. The maximum time to apply heat and reactivate the adhesive is less than 6 hours under most conditions.

Wait for the iron to fully heat up. While waiting, use scissors to cut off the non-glued edges where the veneer was taped.

Reactivate the adhesive with heat

Set the veneer onto the project surface and place a cotton or flannel cloth over the veneer to prevent scorching. Begin ironing from the center and work toward the ends while applying firm downward pressure. It's best to move the iron in the direction of the grain. Generally speaking, it is not advisable to move the iron across the grain. The iron can be used in any direction on burl veneers since this kind of veneer often does not have an organized grain pattern.

With downward pressure, move the iron slowly and give all parts of the veneer ample time to heat up, reactivate, and bond to the substrate. A spritz of Super-Soft 2™ veneer softener applied immediately before ironing may prevent splitting and can help flatten veneer that is slightly buckled.



Check for a strong bond

Inspect the Bond

Visually inspect the panel for any areas that appear loose or uneven after the veneer has cooled. Tapping on the veneer surface with your fingernail can help identify poorly bonded areas. Listen for a hollow sound while tapping, which may indicate a weak bond. These are areas where the adhesive was not fully heated. Also check the edges of the panel for a tight bond. Re-heat areas that did not bond properly. Turn off and unplug the iron when finished.

Finish the panel

Sand and Apply a Finish

Allow an additional 1 to 3 hours for full bond strength to occur. Then carefully sand the veneer panel and apply a stain and/or finish coating as desired. Most stains and finishes are compatible with Heat Lock because of its rigid glue line.